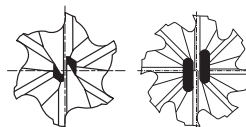


**CARBIDE, 6&8 FLUTE 45° HELIX LONG LENGTH**  
**VOLLHARTMETALL, 6&8 SCHNEIDEN 45° RECHTSSPIRALE LANG**

- ▶ Designed to machine high hardened materials.
- ▶ High speed cutting and finish milling with high feed rates.
- ▶ Superior workpiece finishes.
- ▶ Superior wear resistant.
- ▶ Suitable for dry milling.

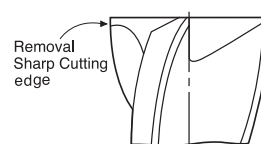
- ▶ Geeignet zum Fräsen von hochgehärteten Stählen.
- ▶ Hochgeschwindigkeitsfräsen und Finishing mit erhöhtem Vorschub.
- ▶ Bessere Werkstückoberflächen
- ▶ Höhere Verschleißfestigkeit.
- ▶ Geeignet zum Trocken-Fräsen.



Unit : mm

EDP No.		Mill Diameter	Shank Diameter	Length of Cut	Overall Length	No. of Flute
PLAIN	FLAT					
EM812060	EM822060	6.0	6	13	57	6
EM812070	EM822070	7.0	8	16	63	6
EM812080	EM822080	8.0	8	19	63	6
EM812090	EM822090	9.0	10	19	72	6
EM812100	EM822100	10.0	10	22	72	6
EM812120	EM822120	12.0	12	26	83	6
EM812140	EM822140	14.0	14	26	83	6
EM812901	EM822901	14.0	16	26	83	6
EM812160	EM822160	16.0	16	32	92	6
EM812180	EM822180	18.0	18	32	92	8
EM812200	EM822200	20.0	20	38	104	8
EM812250	EM822250	25.0	25	44	104	8

Mill Dia. Tolerance(mm)	Shank Dia. Tolerance
0~-0.03	h6



◎ : Excellent ○ : Good

Carbon Steels	Alloy Steels	Prehardened Steels	Hardened Steels		High Hardened Steels	Copper	Graphite	Cast Iron	Aluminum	Stainless Steels	Titanium	Inconel
~HB225	HB225~325	HRc30~40	HRc40~45	HRc45~55	HRc55~70							
○	◎	◎	◎	○								



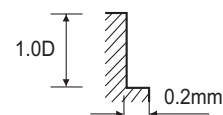
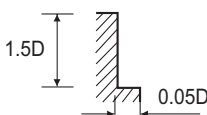
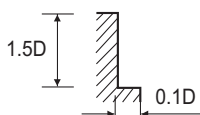
**RECOMMENDED CUTTING CONDITIONS**  
**EMPFOHLENE SCHNEIDKONDITIONEN**

**CARBIDE, 6&8 FLUTE 45° HELIX LONG - SIDE CUTTING**  
**VOLLHARTMETALL, 6&8 SCHNEIDEN 45° RECHTSSPIRALE LANG - SEITENFRÄSEN**

**EM812, EM822 SERIES**

**■ NORMAL SPEED**

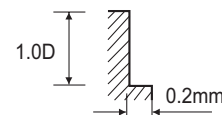
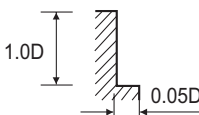
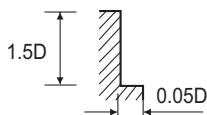
MATERIAL	NON-ALLOYED STEELS ALLOY STEELS		ALLOY STEELS HEAT RESISTANT STEELS		HARDENED STEELS		HARDENED STEELS	
	~ HRC30		HRC30 ~ HRC50		HRC50 ~ HRC60		HRC60 ~ HRC65	
STRENGTH	~ 1000N/mm <sup>2</sup>		1000 ~ 1750N/mm <sup>2</sup>		1750 ~ 2080N/mm <sup>2</sup>		2080N/mm <sup>2</sup> ~	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED	RPM	FEED
6.0	5560	2000	3880	1370	1580	210	1100	130
8.0	4200	2000	2940	1370	1160	210	840	130
10.0	3360	2000	2320	1370	1000	210	680	130
12.0	2840	1680	2000	1160	840	180	560	110
16.0	2100	1260	1480	880	640	130	420	70
20.0	1680	1010	1160	690	500	110	320	60
25.0	1500	900	1100	600	430	90	260	50



RPM = rev./min.  
FEED = mm/min.

**■ HIGH SPEED**

MATERIAL	HEAT RESISTANT STEELS HARDENED STEELS		HARDENED STEELS		HARDENED STEELS	
	~ HRC50		HRC50 ~ HRC60		HRC60 ~ HRC65	
STRENGTH	~ 1750N/mm <sup>2</sup>		1750 ~ 2080N/mm <sup>2</sup>		2080N/mm <sup>2</sup> ~	
DIAMETER	RPM	FEED	RPM	FEED	RPM	FEED
6.0	16800	6090	8400	3050	4200	1470
8.0	12600	6090	6300	3050	3160	1470
10.0	9980	5990	5040	3050	2520	1470
12.0	8400	5040	4200	2520	2100	1260
16.0	6300	3780	3160	1890	1580	950
20.0	5040	3050	2520	1470	1260	760
25.0	4500	2700	2200	1300	1120	670



RPM = rev./min.  
FEED = mm/min.